



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G19432-3G-1

Job Sheet 186573



Part No: RBW6205G19432-3G-1

Job Qty: 4 ea

Part Name: Draw Bolt



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/17/18

Job Tracking No:

Due Date: 12/28/18

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *STU*

Description:

Note: DWG RBW6205G19432-3G Rev 2 IPP Rev A 18.03.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		12/28/18	0.00	0.00	Start Up Machining-3		<i>JB 19-01-18</i>
110	CNC Lathe	4 pcs		12/28/18	0.00	2.00	SL-154		<i>JB 19-01-18</i>
120	QC	4 pcs		12/28/18	0.00	0.00	QC2 Machining-4		<i>JB 19-01-18</i>
130	QC	4 pcs		12/28/18	0.00	0.00	QC8 Machining-4		<i>19/01/20</i>
180	Outsource	4 pcs		12/28/18			GRO002-VC	10	<i>19-01-21</i>
190	Packaging	4 pcs		12/28/18	0.00	0.00	Packaging2		<i>28 JAN 2 8 2019</i>
200	QC	4 pcs		12/28/18	0.00	0.00	QC6		<i>DAS 28 9-89</i>
210	Packaging	4 pcs		12/28/18	0.00	0.00	Packaging3-1		<i>DAS 21 9-89</i>
220	QC21-SA	4 Ea		12/28/18	0.00	0.00	QC21		<i>9-89 JAN 2 8 2019</i>

DAS 62
9-89

Part Op 110 - 1-Machine as per DWG. FB *4996* FOLIO REV: _____ DWG REV: _____ 2-Debur
Descriptions: 120 - Engrave T/N and/or P/N number using Marktronic engraver as per DWG.

180 - Issue P/O to Groupe Altech: P/O *042341* -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.750	AISI 4140 Quenched & Tempered Steel Round Bar 1.750" Dia.	2.8880 ft (.722 ea)	90-Start up Operation	<i>5118653</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140QT-R1.750	3	16	0



Container No: S145995



Part: RBW6205G19432-3G-1

Job No: 186573

Serial No/Batch: S145995

Revision: 2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ations

not be found.

Plex 11/19/18 8:32 AM Dart.lajeunesse.marie

Date: 01/18/19



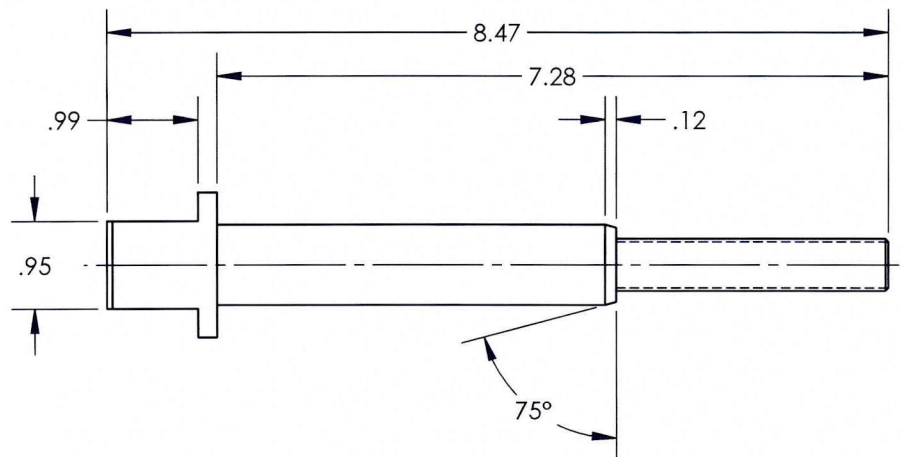
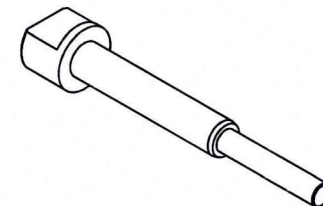
Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework Scrap Use-as-is Suspected Unapproved		AGAINST DEPARTMENT/PROCESS Skid-tube Machining Thermoforming Large Fab Cross tube Small Fab Finishing Composite Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier Engineering Quality Other					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due		FAULT CATEGORY Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence							
OTHER : _____									

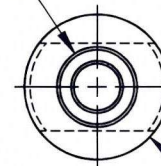
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0031	-1 ADDED MAT'L OPTION 4142 Q&T. CH'D FINISH WAS YELLOW ZINC PLATE IS ZINC PLATE ASTM B633 TYPE I SC2. CH'D DIMS WAS 2.95 IS 2.95, WAS .946 IS .95, WAS .120 IS .12, WAS 7.276 IS 7.28, WAS 1.572 IS ϕ 1.57.	2/11/2016	DPD	JAG

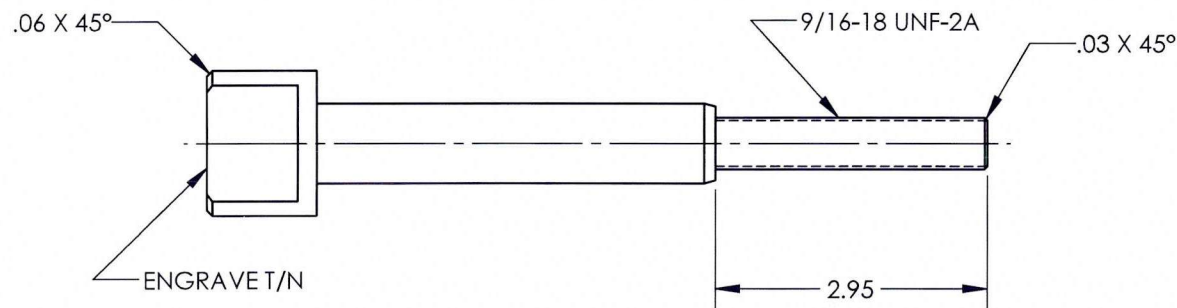
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186573 MWS
1811-19



$\phi .868^{+.000}_{-.002}$



$\phi 1.57$



(-1)

DRAW BOLT

DART AEROSPACE	
TITLE M/R SCISSOR BUSHING INSTALL TOOL	
DWG NO. RBW6205G19432-3G-1	REV 2
MAT'L 4140/4142 Q & T	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm$.005 FRACTIONS $\pm$ 1/8
FINISH ZINC PLATE	.XX $\pm$.01 ANGLES $\pm$ 5°
SPEC ASTM B633 TYPE I SC 2	.X $\pm$.1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	AGUSTA AW139
SCALE 1:2	DATE 7/8/2009
SHEET 2 OF 6	

RBW6205G19432-3G-1

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
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PURCHASE ORDER PO042341



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042341
PO Date: 1/21/19
Due Date: 1/25/19
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186062	RBE105-31702W14-1	Drift -Issue P/O; -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed	-	1/25/19	9 pcs	0 pcs	9 pcs	\$2.6470588/pcs	\$23.82
Line Item Note ** asap : (**											
2	188456	RBW6430G02931-8G	Extractor YELLOW OR BLACK ZINC PER ASTM B633 TYPE 2 CLASS 2 CERTIFICATE OF CONFORMANCE IS REQUIRED	Firmed	-	1/25/19	6 pcs	0 pcs	6 pcs	\$2.6470588/pcs	\$15.88
3	188502	RBEL135M-2901-101-21	Slide -Issue P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required	Firmed	-	1/25/19	10 pcs	0 pcs	10 pcs	\$9.00/pcs	\$90.00

Line Item Note ** NEED BY FRIDAY 01/25 **



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PURCHASE ORDER

PO042341



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	187498	RB T103216-101	Spanner Assembly Outsource13 (Outside Processing - Zinc Plating) -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed	-	1/25/19	4 pcs	0 pcs	4 pcs	\$2.6470588/pcs	\$10.59
5	186570	RBW6205G19332-3G-1	Draw Bolt -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required	Firmed	-	1/25/19	5 pcs	0 pcs	5 pcs	\$2.6470588/pcs	\$13.24
6	186573	RBW6205G19432-3G-1	Draw Bolt -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required	Firmed	-	1/25/19	4 pcs	0 pcs	4 pcs	\$2.6470588/pcs	\$10.59

Line Item Note ** For Friday morning please **

7	188457	RBW6521G00131-8G	Oil Seal Installation / Removal Kit YELLOW ZINC PER ASTM B633, TYPE 2 CLASS 2	Firmed	-	1/25/19	6 pcs	0 pcs	6 pcs	\$8.8970588/pcs	\$53.38
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Line Item Note:

Certificate of conformity is required



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PURCHASE ORDER PO042341



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Grand Total:											\$217.50

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/22/19 10:46 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(016161-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

016161 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
22-Jan-2019		Aman		042341 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE105-31702W14-1 ✓ Rev.	RBE105-31702W14-1 ZINC PLATE ASTM B633 TYPE 2 SC2	ZINC CH	9	9 ✓	0	0	0
2	RBW6430G02931-8G ✓ Rev.	RBW6430G02931-8G ZINC PLATE ASTM B633 TYPE 2 CLASS 2	ZINC CH	6	6 ✓	0	0	0
3	RBEL135M-2901-101-21 ✓ Rev.	RBEL135M-2901-101-21 ZINC PLATE ASTM B633 TYPE 1 SC2	ZINC CH	10	10 ✓	0	0	0
4	RBT103216-101 ✓ Rev.	RBT103216-101 ZINC PLATE ASTM B633 TYPE 2 SC2	ZINC CH	4	4 ✓	0	0	0
5	RBW6205G19332-3G-1 ✓ Rev.	RBW6205G19332-3G-1 ZINC YELLOW ASTM B633 TYPE 2 SC2	ZINC CH	5	5 ✓	0	0	0
6	RBW6205G19432-3G-1 ✓ Rev.	RBW6205G19432-3G-1 ZINC YELLOW B633 TYPE 2 SC2	ZINC CH	4	4 ✓	0	0	0
7	RBW6521G00131-8G ✓ Rev.	RBW6521G00131-8G STRIP ZINC YELLOW PER ASTM B633 TYPE 2 CLASS 2	ZINC CH	20	20 ✓	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.